

the base plate, the stepped portion and at least a part of the flange[d]-shaped portion between a circular bottom pattern tool and a circular top pattern tool; applying recessed annular forming faces of circular rollers of plural kinds against the flange-shaped portion and sequentially pressing the flange-shaped portion projecting outwardly from the circular bottom pattern tool and said circular top pattern tool, in a radially inward direction, thereby sequentially thickening a rear side of the flange-shaped portion; and forming the thickened flange-shaped portion into a cylindrical shape which is concentric with the base plate, thereby forming the thickened annular peripheral wall.

Please add the following new claim:

8. A method of forming a thickened annular peripheral wall of a sheet metal member, comprising the steps of:

holding the sheet metal member and forming from the sheet metal member a base plate, a stepped portion and a flange-shaped portion connected integrally by the stepped portion with an outer periphery of the base plate; inserting the base plate, the stepped portion and at least a part of the flange-shaped portion between a circular bottom pattern tool and a circular top pattern tool; applying recessed annular forming faces of circular rollers of plural kinds against the flange-shaped portion and sequentially pressing the flange-shaped portion projecting outwardly from the circular bottom pattern tool and said circular top pattern tool, in a radially inward direction, thereby sequentially thickening a rear side of the flange-shaped portion; and forming the thickened flange-shaped portion into a cylindrical shape which is concentric with the base plate, thereby forming the thickened annular peripheral wall;